

Work Order ID 51313

August 19, 2009 6:56:44 AM



Page 1

Item ID: D2282-043
Revision ID: E
Item Name: Saddle Assembly

Accept



Setup Start



Stop



Start Date: 8/18/09 Start Qty: 34.00
Required Date: 8/18/09 Req'd Qty: 34.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf*
QC:

Date: 09-08-19 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID Operation
Description

Set Up/
Run Hours

Draw Draw Plan Accept Reject Reject Insp.
Number Rev. Code Qty Qty Number Stamp

Draw Nbr Revision Nbr

D2282 Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-043 Saddle Assembly: 1A/RER316L SS Filling
Rod: *110875* Dwg Rev: *E*

SP 09.08.24.

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- grind weld flush, take all welding marks out and deburr holes

SP 09.08.24.

m-h

09/08/25

(34X)

120

0.00



QC9- Inspect visual per QS1004- Fusion Welds

QC

Memo

0.00

Quality Control

Pl 09.08.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



Item Name: Saddle Assembly

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> S or 10/25

count
(+34)

✓

140



Small Fab

Small Fab

Small Fab

Memo

I-tumble

0.00

0.00

B 9-8-2L

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> S or 10/26

count
(+34)

✓

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Accept



Setup Start



Stop



Start Date: 8/18/09 Start Qty: 34.00
Required Date: 8/18/09 Req'd Qty: 34.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 261

0.00

Memo

0.00

09/08/2009 34

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/2009

09F-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 19, 2009 6:56:43 AM

Page 1

Work Order ID: 51313

Parent Item: D2282-043RevE

Parent Item Name: Saddle Assembly

Comments:

Start Date: 8/18/09

Required Date: 8/18/09

Start Qty: 34.00

Required Qty: 34.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2281RevG

Manufactured

No

100

Each

33.0000

34.0000



Jack Saddle



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

→ 50658

*Adj-

33

33

34

100

Each

102.0000

68.0000

D2282-7RevE

Manufactured

No



Tube



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

102

46690

50

48283

52

34

SP09.08.19

50
18

SP09.08.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

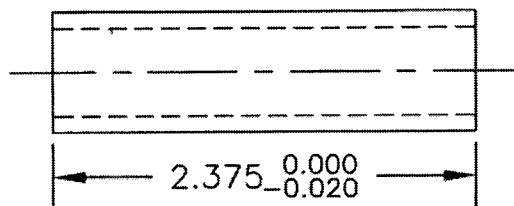
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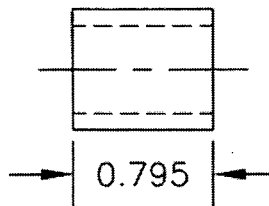
NOTE: Date & initial all entries

6/5/37
mk
9-08-19
DART

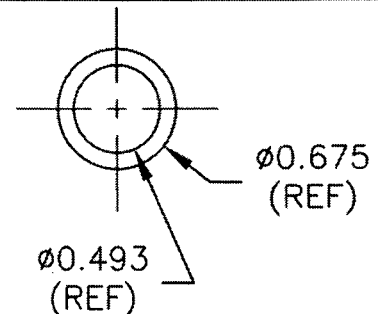
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



D2282-3

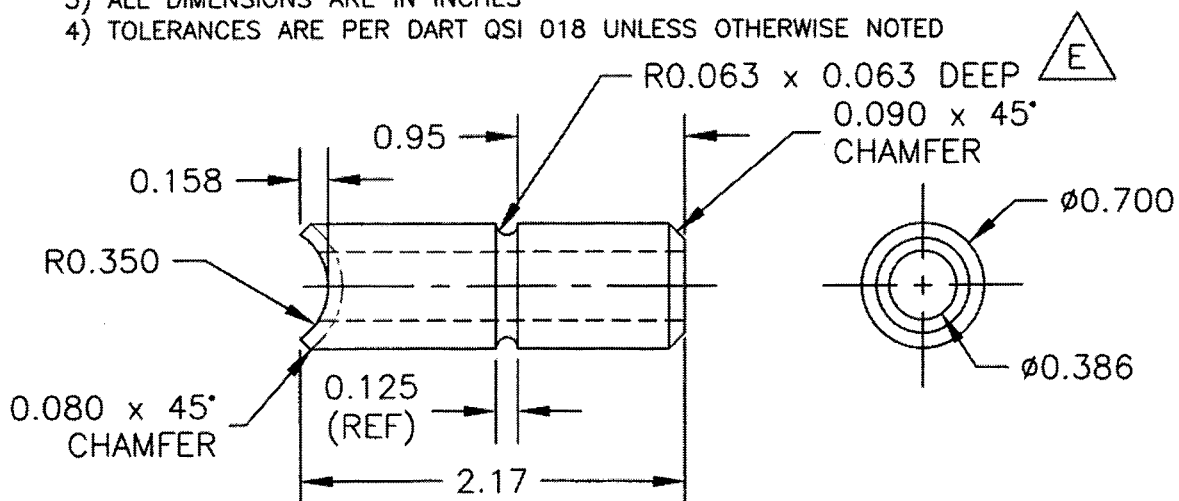


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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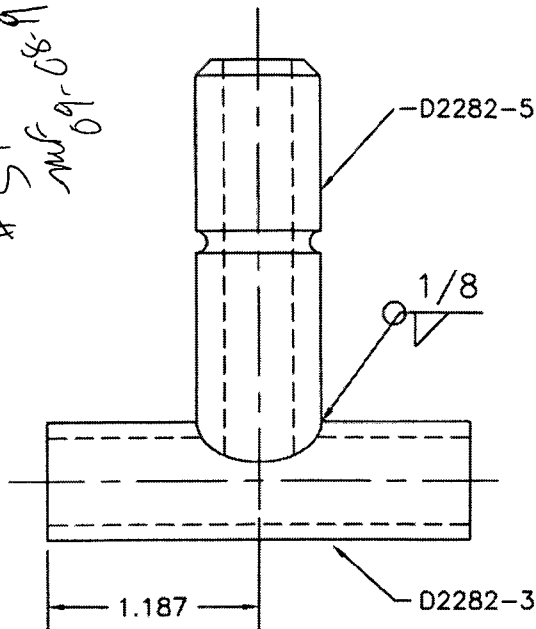
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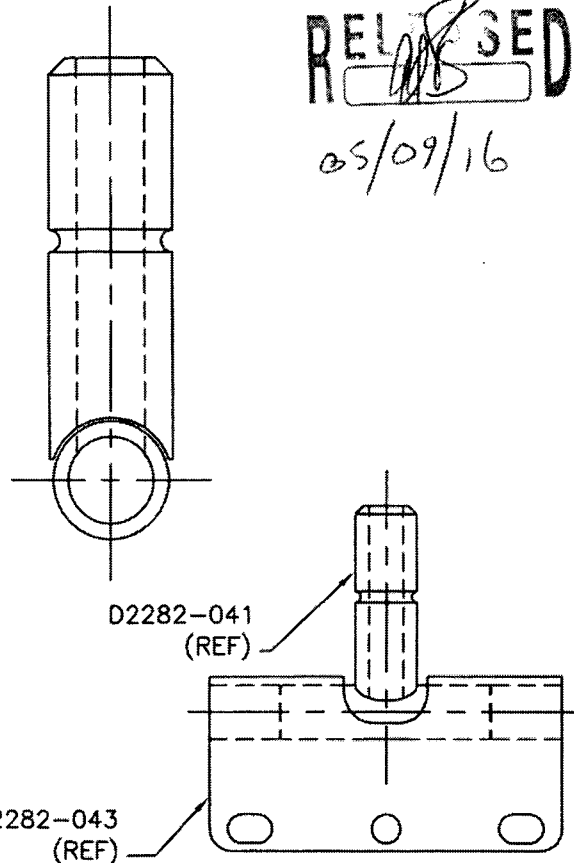
NOTE: Date & initial all entries



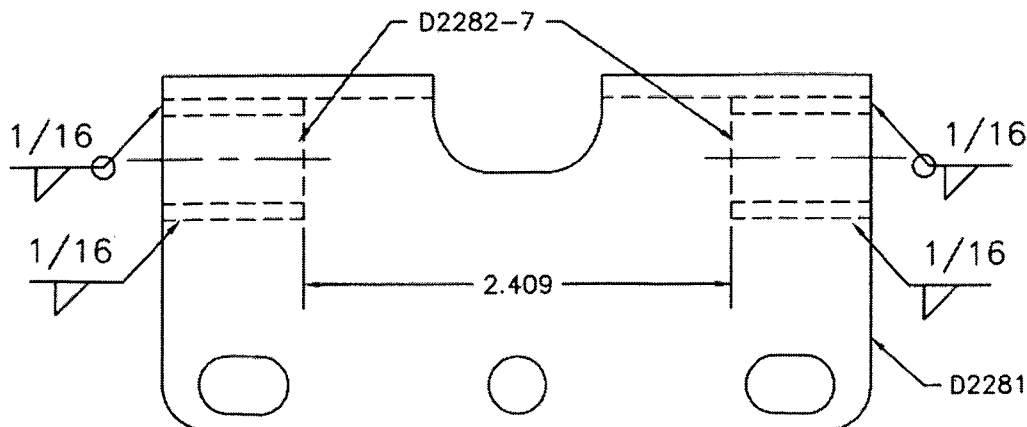
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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Dart Aerospace Ltd

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